

Work Order ID 66465

Tuesday, February 15, 2011 11:25:56 AM



Page 1

Item ID: D2221	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: 350 Basket Base					
Start Date: 2/16/2011	Start Qty: 1.00		Cust Item ID:		
Required Date: 2/28/2011	Req'd Qty: 1.00		Customer:		
Reference:					

Approvals:	Process Plan: <i>mt</i>	Date: 11-02-11	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2221	Rev H								

100		0.00							
	Large Fab								
Large Fab		0.00							
Large Fab									

Memo

- 1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
 - 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
 - 3- tack weld mesh on basket as per dwg D2221
- A/R ER316 S.S. Rod Batch: *4119649*

PLEASE NOTE

IF MAKING -041A OR -043A :
DRILL HOLES FOR GAS SPRING
IN D3825-041 AS PER
DSI 9473

110		0.00							
	QC9- Inspect visual per QSI004- Fusion Welds								
QC		0.00							
Quality Control									

Memo

Pl 11.03.14

11.03.11 *(1x)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66465

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Item ID: D2221

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 Basket Base

Start Date: 2/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8/11/09/114



125

Pressure Wash per QS1005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BL 11-3-14.

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

1. The first step in the process is to identify the problem. This involves gathering information about the situation and the people involved.

2. The second step is to analyze the problem. This involves breaking the problem down into smaller parts and understanding the causes.

3. The third step is to develop a plan. This involves deciding on the best way to solve the problem and setting goals.

4. The fourth step is to implement the plan. This involves putting the plan into action and making changes as needed.

5. The fifth step is to evaluate the results. This involves checking to see if the problem has been solved and if the goals have been met.

6. The sixth step is to reflect on the process. This involves thinking about what worked well and what could be improved for next time.

7. The seventh step is to share the results. This involves telling others about what you have learned and how you solved the problem.

8. The eighth step is to continue to learn. This involves staying open to new ideas and ways of solving problems.

9. The ninth step is to be a role model. This involves showing others how to solve problems and how to work together.

10. The tenth step is to be a team player. This involves working well with others and helping them to solve their problems.

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Accept

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Setup Start

Abstract

Stop

[illegible]

Start Date: 2/16/2011 **Start Qty:** 1.00

REMARKS:

Cust Item ID:

Required Date: 2/28/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start

Abstract

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



**Insp.
Stamp**

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Powdercoat

Memo

0.00

Powder Coating

1- Plug holes prior to

1ST COAT:

START TIME:

OVEN TEMPERATURE: _____

FINISH TIME:

*****2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE: _____

FINISH TIME:

140

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

EP 11/03/15 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66465

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Item ID: D2221

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 Basket Base

Start Date: 2/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location:

GA

0.00



Packaging

Memo

w/o 66464

0.00

Packaging

EP 11/03/15 @

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/15 J

ME
11-03-15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Page 1

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves assigning tasks to team members, setting deadlines, and monitoring progress to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves comparing the actual outcomes with the objectives and goals to determine the effectiveness of the project and identify areas for improvement.




Parent Item Name: 350 Basket Base

Required Date: 2/28/2011

Required Qty: 1.00

Comments:

IPP Rev:J	05.09.02	Added D3442-1	□KJ/JLM	
IPP Rev:K	08-08-29	revG as per dwg	DD verified by:EC	
IPP Rev:L	08-09-24	plug holes prior to powder coat	DD verified by:EC	
IPP Rev:M	08-12-02	revH as per dwg	DD verified by:EC	IPP Rev:N
	10.06.29	added pressure wash	DD verf:EC	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2221-1  Rib		Manufactured	No			100	Each	11.0000	1	1		11.03.08	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				11					
					63628			2					
					64651			9					
✓ D2221-5  Rib		Manufactured	No			100	Each	6.0000	2	2		11.03.08	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				6					
					64652			6					
✓ D2221-7  Rib		Manufactured	No			100	Each	3.0000	1	1		11.03.08	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				3					
					64653			3					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, February 15, 2011 11:25:49 AM

Page 2

Work Order ID: 66465

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 2/16/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D2232-3 Manufactured No 100 Each 8.0000 2 2
Basket Hinge
11.03.08

Location Loc Qty Loc Code

WA 8
64578 2
65418 6

✓ D2235-1 Manufactured No 100 Each 6.0000 2 2
Basket Rib
11.03.08

Location Loc Qty Loc Code

WA 6
64626 2
64898 4

✓ D2581 Manufactured No 100 Each 30.0000 2 2
Mounting Bracket
11.03.08

Location Loc Qty Loc Code

WA 30
64112 7
65950 23

✓ D3442-1 Manufactured No 100 Each 25.0000 2 2
Shim
11.03.08

Location Loc Qty Loc Code

ST 10
64271 10
WA 15
65783 15

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 66465

Parent Item: D2221



Parent Item Name: 350 Basket Base

Start Date: 2/16/2011

Required Date: 2/28/2011



Start Qty: 1.00

Required Qty: 1.00

✓ D3825-041 Manufactured No 100 Each 2.0000 2 2

 Rib Assembly (Basket End)  B65419 (2x) 11.03.08



Location Loc Qty Loc Code

WA 2
 64577 2

✓ D3826-041 Manufactured No 100 Each 8.0000 2 2

 Rib / Gusset Assembly  11.03.08



Location Loc Qty Loc Code

WA 8
 64690 2
 65420 6

✓ D3827-041 Manufactured No 100 Each 10.0000 1

 Rib Assembly (Inboard)  (2x) 11.03.08

Location Loc Qty Loc Code

WA 10
 64857 4
 65485 6

✓ D3832-1 Manufactured No 100 Each 3.0000 1

 Mesh (Base)  1 11.03.09

Location Loc Qty Loc Code

WA 3
 65313 3

Tuesday, February 15, 2011 11:25:50 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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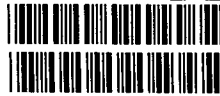
NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 66465



Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 2/16/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

D3833-1

Manufactured No

100

Each

18.0000

2

2



Mesh (Base End Face)



11.03.09

Location

Loc Qty

Loc Code

WA

18

64246

2

64891

8

65937

8

2

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Shop Packet Print

Page 4

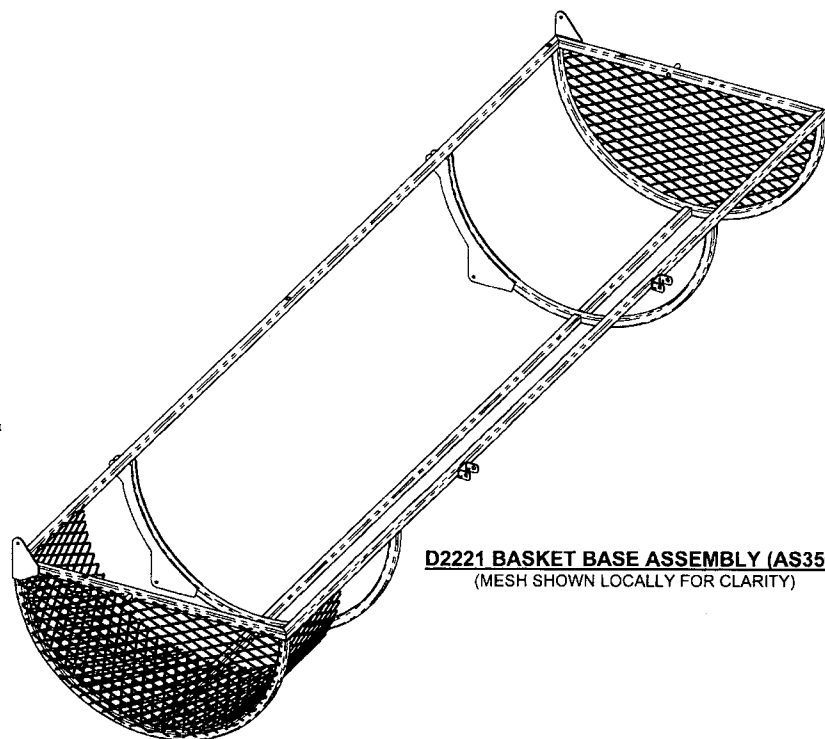
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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING



ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

#66065

RECEIVED
08/11/18

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN D6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

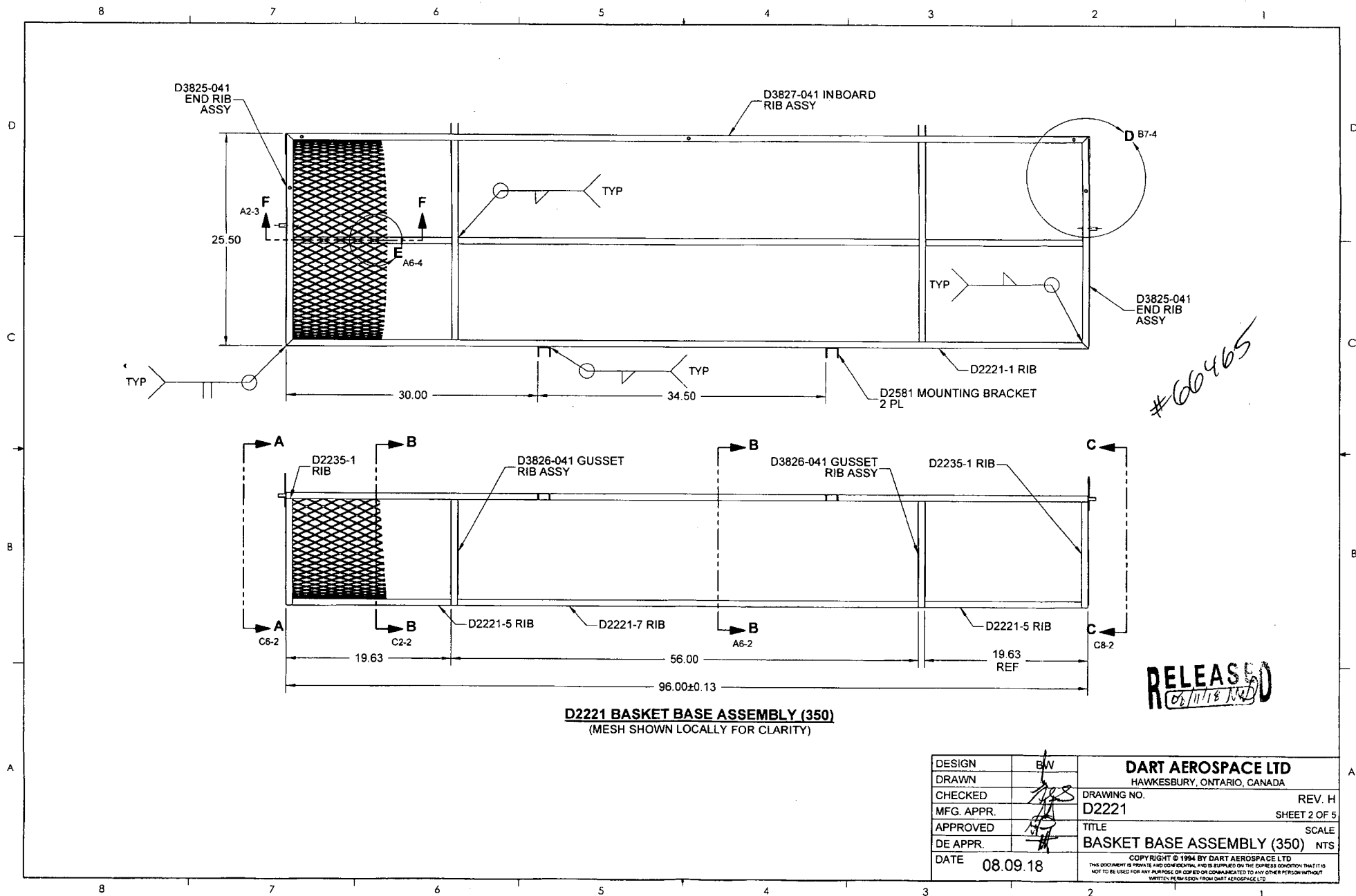
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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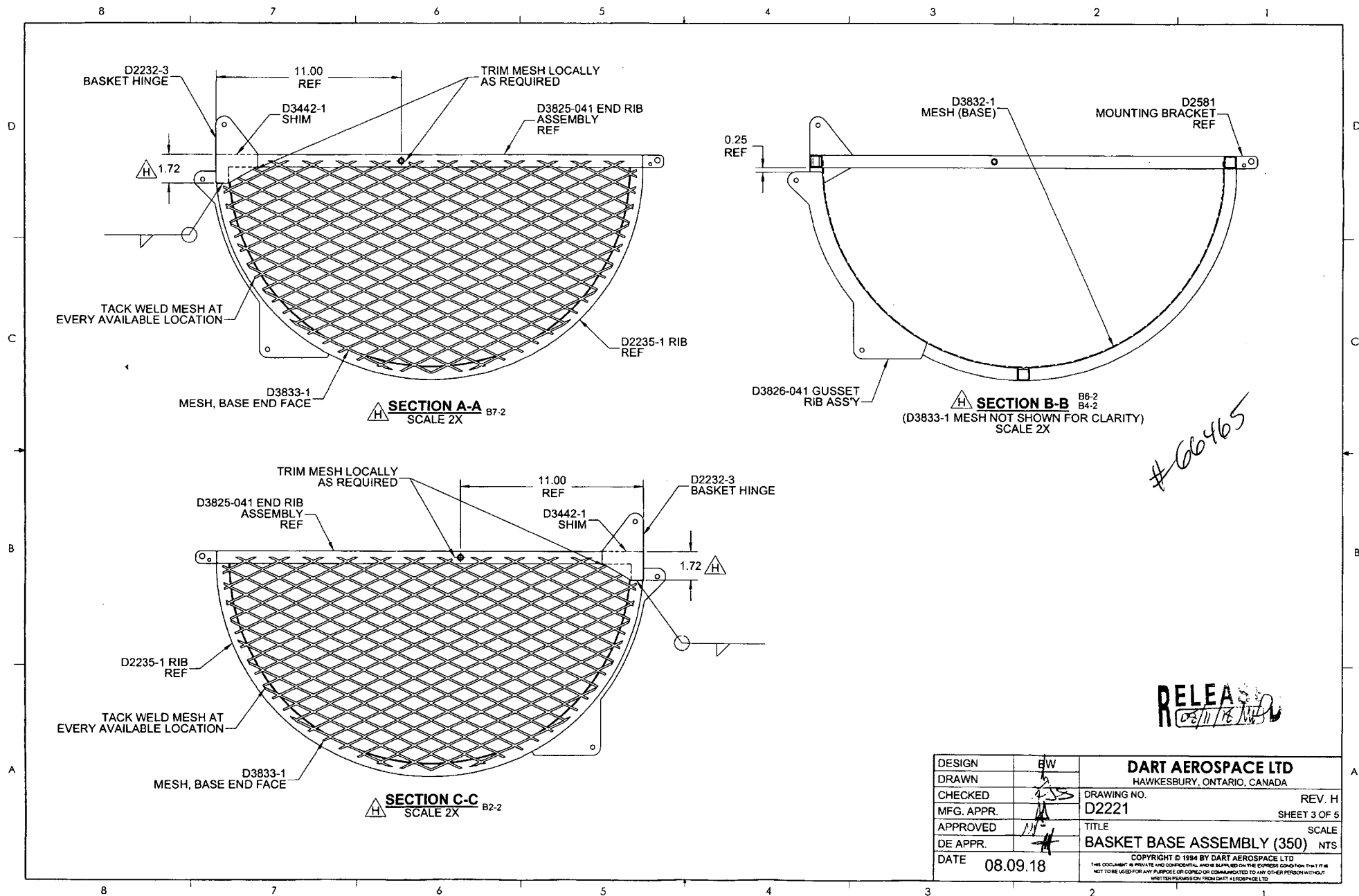
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



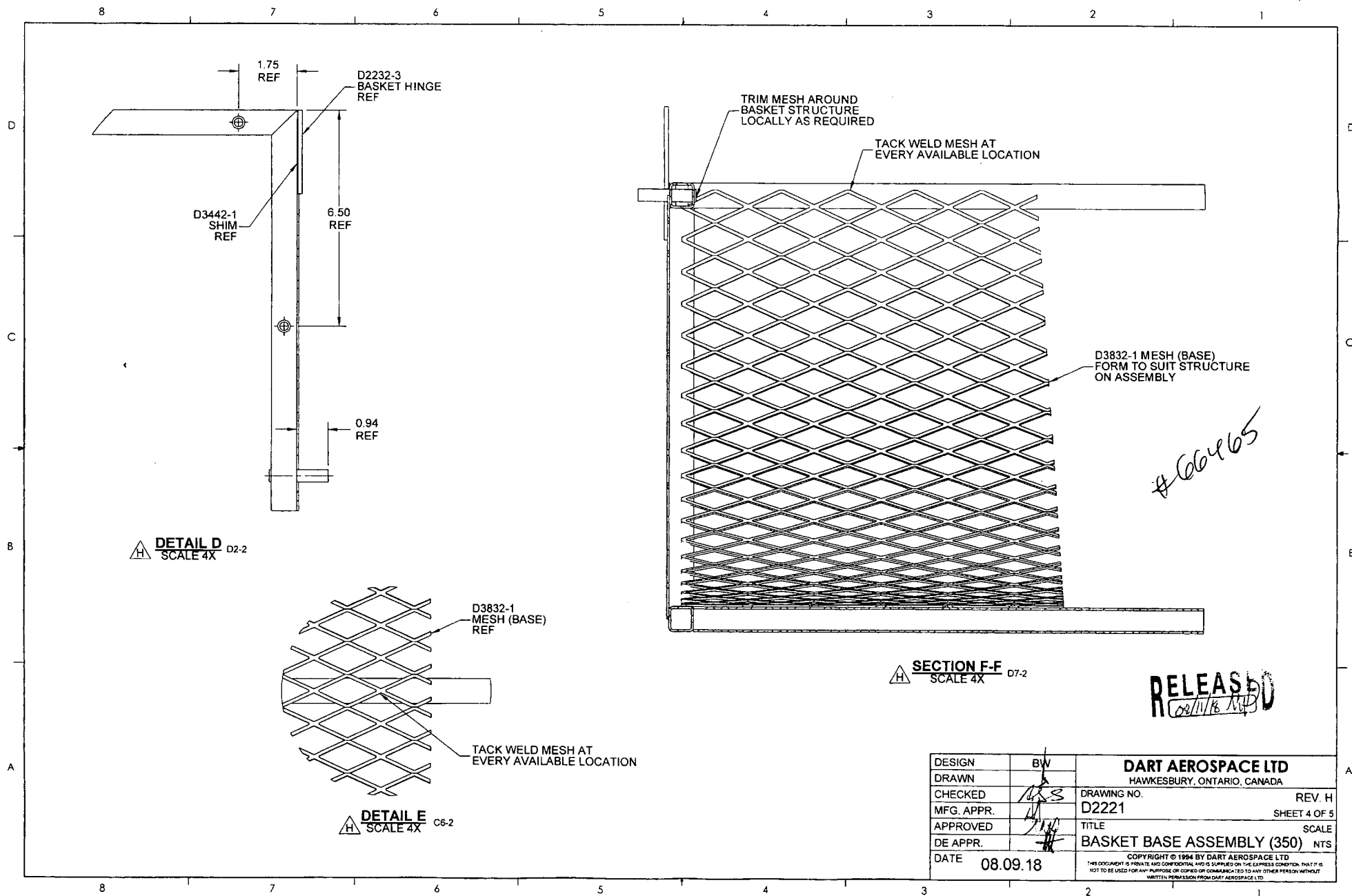
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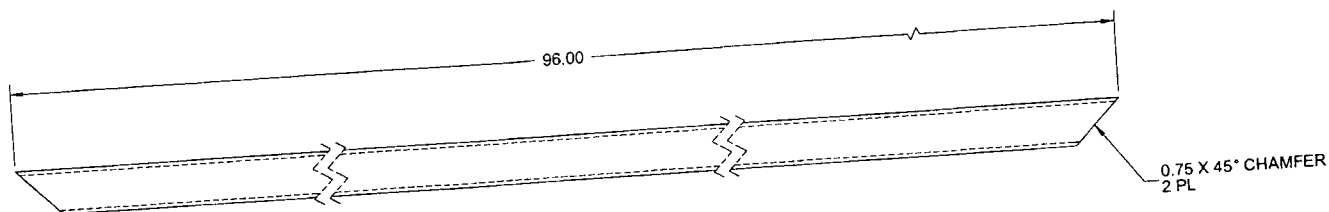
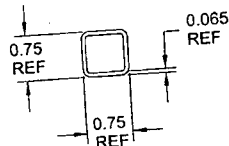
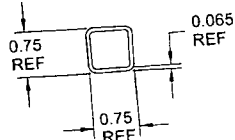
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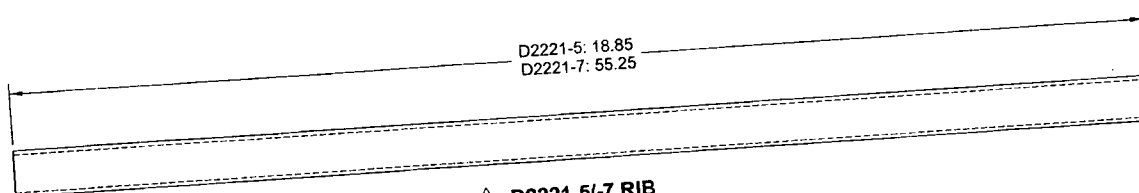
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2221-1 RIB



D2221-5/-7 RIB

#66465

RELEASED
08/11/18

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS	DRAWING NO.	REV. H
CHECKED	MS	D2221	SHEET 5 OF 5
MFG. APPR.	W	TITLE	SCALE
APPROVED	W	BASKET BASE ASSEMBLY (350)	NTS
DE APPR.	W	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.09.18		

W/O:

WORK ORDER CHANGES

PROCEDURE CHANGE

DATE	STEP		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:								
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Quality Assurance approved QAINCRWO RevE